

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012272**Date Inspected:** 24-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Mike Johnson, Jesse Cayabayab**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG 1E/2E-D**Summary of Items Observed:**

The Quality Assurance (QA) Inspector, Rick Bettencourt was on site at the job site between the times noted above.

The QA Inspector was on site to randomly observe the in process joint restoration and welding of the 1E/2E-D.

The following observations were made:

1E/2E-D

Upon the arrival of the QA Inspector at the above identified location, the Smith Emery (SE) Quality Control (QC) Inspector was observed performing magnetic particle testing (MT) of the areas that had been previously welded.

The QA Inspector noted upon arrival the entire weld joint including the areas D9/D10 (90% complete) and D13/D14 (25% complete) was cold to the touch or ambient temperature. It was observed by the QA Inspector no relevant MT indications were located by the SE QC Inspector at the time of the testing. It is noted an incident report was written and generated on the previous date for the failure to maintain the minimum required preheat.

The ABF Welding Quality Control Manager (WQCM) Jim Bowers informed the QA Inspector no welding repairs would be made prior to Caltrans Engineering approval.

The QA Inspector randomly observed the ABF welding personnel performing grinding tasks of the areas where cracks were previously located. The QA Inspector randomly observed the ABF welders utilizing burr bit grinders removing weld material against the bevel on one side of the joint where the cracked areas were located. The QA Inspector randomly observed and noted the ABF personnel spent the majority of the shift performing the grinding tasks noted above. After the cracks were removed by grinding the QA Inspector randomly observed the QC Inspector perform MT of the areas to ensure the cracks had been completely removed. The QA Inspector randomly observed and noted no relevant indications were located at the time of the testing. The QA Inspector noted no

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welding was performed on today's shift. The QA Inspector was informed by the QA Lead Inspector Bill Levell, the ABF procedure for repairing the cracked areas was approved.

The previously submitted repair procedure was reviewed and approved by Caltrans Structures Representative Senior Brian Boal at 1430. It was determined by the ABF Welding Supervision, due to lack of time remaining in the shift, no welding would be performed on today's date.

It was noted by the QA Inspector it appears the the contractor is in general conformance with the field erection sequence plan, submittal number ABF-SUB-001135.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916)-813-3677, who represents the Office of Structural Materials for your project.

Inspected By:	Bettencourt,Rick	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
